

5/18

DART AEROSPACE LTD.	Work Order:	22977
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	12
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HJ	05.04.13	12
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B21818	BG	05/04/15	12
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: B21817A	BG	05/04/15	12
4	MV	Fixturing W/O No. <u>N/A</u> Fixturing Inspection last completed 05/04/16 by BG	BG	05/04/15	12
5	MV	Program Batch No. <u>22977</u> Double check by: BG	EP	05/04/16	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	EC/BG	05.04.25	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	EC/BG	05.04.25	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	EC/BG	05.04.25	12
9	MV	Machine keyway as per dwg D2571 & D2572	EC/BG	05.04.25	12
10	MV	Deburr and remove all machining marks	EC/BG	05.04.25	12
11	MV	Tumble for 20 minutes to remove sharp edges # 04.06.21	EC/BG	05.04.25	12
12	QC1	Inspect all dimensions to dimension sheets	BG/BG	05.04.25	12
13	QC7	Second inspection	JJ	05.04.25	12
14	FP	Acid etch and alodine as per QSI 005 4.1	M	05.04.27	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	M	05.05.02	12
16	QC3	Inspect Powder Coat	CL	05/05/03	12
17	ST	Identify and Stock.	CL	05/05/03	12
18	AC	Cost / Part <u>187.45</u> <u>150.72</u>	JAC	05.05.05	12
19	DC	Close W/O <u>175.42</u> <u>150.72</u> Inspection Level 21	HJ	05.05.11	12

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED
02/10/15 RF